October-19-12 2:44:12 PM

Page 1

Item ID: 646.9501 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: 206 Cable Cutter, High 19/10/2012 Start Qty: 1.00 **Start Date: Cust Item ID: Required Date:** 02/11/2012 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: MLJ Date: 12-10-19 Tooling: Approvals: Date: QC: \_\_\_\_\_ Date: \_\_\_\_ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. **Work Center ID** Description Run Hours Qty Qty Code Number Stamp Draw Nbr **Revision Nbr** 646.9500 N/C 100 0.00 DAS DOCUMENT CONTROL \*100\* 27 9-89 DC 0.00 Memo Document Control Photocopy bluefile & type labels per PPP 646.9501 110 Pick Kit 0.00 \*110\* Packaging 0.00 Memo Packaging DAS 27 9-89 120 QC4- 100% Inspect kits for completeness 0.00 \*120\* QC 0.00 Memo Quality Control

NCR: \	es / No				WORK ORDER NON-C	COL	NFOR	MANCE / UPI	DATE	QA Closed:	Date	·	
Win 2 .		·											
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	•	
					Rework	1	-	Skid-tube	Crosstube		Water Jet	Engineering	
Part N	lo.				Scrap	1	ı	Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
					Use-as-is		Thern	noforming	Finishing	Rec/Stor	re/Packaging	Other	
NCR N	lo				Work Order Update	]		Large Fab	Composite		Supplier		
Root				Descri	Iption of work order update		nitial	Act	tion	Sign &			
Cause	Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector	
Doc/Data											-		
Equip/Tooling													
Operator													
Material													
Setup													
Other			1										
Process													
Supplier													
Training													
Unapproved		<u> </u>			F	ΔΠ	T CATE	L	<u> </u>	l	L		
Landir	ng Gear				General		- CAIC						
	Bending				Bend		Grain			Ovalized	Γ	Pressure/Forced	
	Centre N	ot Conce	ntric to C	o/s 🗀	BOM/Route	$\vdash$	  Hardwa	re		Over/Under	tolerance	Temperature/Cure	
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	<u></u>	Weld	
*	Crushed/	_			Burrs		1	ions Incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	<del> </del>				Contamination		Mainte	nance		Part Moved	_		
	Heat Treat Countersink						Mislabe	led		Positioned V	Vrong		
İ	Inspection Strip in Tube Cut Too Short					Misread Power Loss/Surge Other					Other		
	Ripples in	n Bend			Drill Holes		Offset						
	Torque V	Vaves in E	Extrusion	·	Drawing		Out of (	Calibration					
	Turning S	Sequence			Finish		Out of S	equence					

Outside Dimensions

DQA:\_\_\_

Date: 🖺

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

October-19-12 2:44:12 PM

Page 2

Item ID: 646.9501 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: 206 Cable Cutter, High **Start Date:** 19/10/2012 **Start Qty:** 1.00 **Cust Item ID: Required Date:** 02/11/2012 **Req'd Qty:** 1.00 **Customer:** Reference: Run Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_ Tooling: Date: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 130 0.00 Packaging \*130\* Packaging 0.00 Memo Packaging Identify and pack for shipping as per PPP 646.9501 Location: +6092 140 QC21- Final Inspection - Work Order Release 0.00 / Km 13/9/26
Wi 309.04 \*140\* QC 0.00 Memo Quality Control

NCR:	Yes	/ No				WORK ORDER NON-	·CO	NFORM	MANCE / UP	DATE			
								<b>.</b>			QA Closed:	Date	:
Work Ord	er:					DISPOSITION				AGAINST DI	EPARTMENT	/PROCESS	: 
Pärt   NCR	•					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Cł	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved							FAUI	LT CATE	GORY				
Landi	ing G	Gear				General		_			_	_	
		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in	Crimped at n Strip in n Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	ion Incomplete ions Incomplete/ enance eled	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned	ect lissing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
1	1 1	Torque W	raves in E	xtrusior	1	Drawing	- 1	1Out of C	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date: 1

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

October-19-12 2:44:15 PM

Work Order ID: 92039

\*92039\*

Parent Item:

646.9501

\*646 9501\*

Parent Item Name: 206 Cable Cutter, High

**Start Date:** 19/10/2012

**Required Date:** 02/11/2012

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9601	S. B	Manufactured	No			110	Each	0.0000		1			
<b>*646_9601</b> Upper Cutter Assembly	* 0 M								**	912	83 21	3	GV
646.9602		Manufactured	No			. 110	Each	0.0000	$\overline{\Box}$	1			:Q4
*646-9602	*>SW							0.000	**	9/2	88 21	3	88
Lower Cutter Assembly, Hig 646.9810	i i	Manufactured	No			110	Each	0.0000			<i>j</i>		
*646-9810	* SH								**	1644	145 21	<b>b</b>	36
Deflector 647.0210	Onr	Manufactured	No			110	Each	0.0000		1			
*64 <del>7</del> -0210	* ~1 \								**	9144	10 28		88
647.0110	SAP	Manufactured	No			110	Each	0.0000		1			
*647_0110	*								**	897	03 JB	<u>}</u>	88
Roof Doubler 647.0310	Ship	Manufactured	No			110	Each	0.0000	2	2	0		
*647_0310	*								**	_	2 28	(	R
Channel 646.9910	SINP	Manufactured	No			110	Each	0.0000	4	4	_		
*646_9910;	*								**	93/8	9 78	500	
Strut 547.0112	Ship	Manufactured	No			110	Each	0.0000	$\sqrt{8}$	8	<i>V</i>	,_0.X	- · • • • • • • • • • • • • • • • • • •
*647-0112	5								**	919	75 2	, ; ;	3-09-

NCR:	Yes	/ No				WORK ORDER NON-	100	NFORM	MANCE / UPI	DATE					
											(	QA Closed:	Dat	te:	
Work Ord	er:					DISPOSITION	١.		,	AGAINST [	DEP.	ARTMENT	-		
Part i					·	Rework Scrap Use-as-is		l Therm	Skid-tube Machining moforming	Crosstube Small Fab Finishing			Water Jet d. Eng. Coor. e/Packaging		Engineering Quality Other
NCR I	NO.		<u> </u>			Work Order Update	_		Large Fab	Composite			Supplier		
Root Cause		Date	Step	Qty		ption of work order update or Non-conformance		Initial nief Eng	Act Descr	ion iption		Sign & Date	Verification	n	QC Inspector
Doc/Data Equip/Tooling Operator Material* Setup Other Process Supplier Training															
Unapproved <sup>7</sup>			<u> </u>	<u> </u>		-	<u> </u>	T CATE	CORY						•
Landi	na (	Geor				General	AUL	T CATE	JURY						· .
r Lanui		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples ir	Crimped at n Strip in n Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misreac Offset	on Incomplete ions Incomplete/I nance led I	Jnclear		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Torque W	/aves in E	xtrusio	n [	Drawing	L	Out of C	Calibration						

Out of Sequence

Outside Dimensions

DQA:

Date: \*

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

October-19-12 2:44:16 PM

Work Order ID: 92039	)		*9203	9*							
Parent Item: 646.9	501		*646								
Parent Item Name: 20	06 Cable Cutter, I	High	(,(, ,	,,,,,,,				tart Date: 19 Start Qty: 1.0		Required Da Required Q	te: 02/11/2012 ty: 1.00
647.0113	,	Manufactured	No		110	Each	0.0000		2	•	-
*647 0113 Strut Doubler	* 540							**	12621	19 20	W.
647.0111		Manufactured	No		110	Each	0.0000		1		
Panel	* 5mB							**	89	763 JB	87
647.0116		Manufactured	No		110	Each	0.0000	2	2		
*647-0116	* Smb							**	89	<b>6</b> 99	SP
647,0410		Manufactured	No		110	Each	0.0000		1 –		
*647-0410	^							**	90491	39	
647.0114	SmB	Manufactured	No		110	Each	0.0000		1 _	•	
*647 0114								**	12621	19 78	<del>(</del>
647.0115	ShP	Manufactured	No		110	Each	0.0000		1 /		ØK
*647-04-15	* < wD			•				**	12624	9 20	<del></del>
NAS1149FN832P		Purchased	No		110	Each	523.0000	111	111 /		0.8%
*NAS1149 Washer	EN8321	<b>P*</b> 2					,	**	123900	13	-09-03
	SM.	,	Location	<u>on</u>	<u>Lo</u>	c Oty	Loc Code			A	
			275			198		_		-	
			077277	122441		198		_		-	
			ST275	115158		125 125		_		-	
			ST294	110100		200		-		-	
			51274	123352		200		-		•	
								_		-	

NCR:	Yes	/ No				<b>WORK ORDER NON-</b>	CO	NFORM	MANCE / UP	DATE			
											QA Closed:	Date:	
Work Orde	er:					DISPOSITION				AGAINST DE	EPARTMENT,	/PROCESS	
Part N	-					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	-4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	Ĭ				Descri	ption of work order update		Initial	Act	tion	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Cł	nief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	à		\$	To the state of th	·		<b>ΕΔ111</b>	LT CATE	GORY				
Landii	ng G	iear	,			General							
		Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection Ripples in	ot Concer Crimped. t n Strip in Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/I nance led	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Torque W	aves in E	xtrusior	1	Drawing	- 1	Jour of C	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date: "

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

October-19-12 2:44:16 PM

Work Order ID: 92039

646.9501

Parent Item Name: 206 Cable Cutter, High

Parent Item:

\*92039\*

\*646 9501\*

Location

**Start Date:** 19/10/2012

**Required Date:** 02/11/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

Purchased

Purchased

No

No

No

110

Each

1,274.000

Loc Code

500.0000

Loc Code

123900 JB

Locatio	Ū	<u>Loc Q</u>	<u>ity</u>	Loc Code	
275		2	298		
	122441	2	298		
ST275			776		
	117735		13		
	119225		8		
	121259	j	138		
	121825		14		
	122063	6	500		
	17317		3		
ST295		2	200 .		
	123352	2	200		
		110	Each	346.0000	1

AN3-11A

<b>Location</b>	Lo	c Qty
ST351		346
110865		46
115457		100
123352		200
	110	Fach

7×123525 13-09-03

Location Loc Qty ST315 500 123352 500

10 × 123352

NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	AANCE / UPDATE				
, =						_					QA Closed:	Date	:
Work Ord	er:					DISPOSITION			AGAIN	IST DE	PARTMENT	/PROCESS	
Part I	No.					Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Large Fab Composite  iption of work order update Initial Action				ab	•	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Action		Sign &		
Cause		Date	Step	Qty		or Non-conformance	Cł	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
۵						F	AUI	LT CATE	GORY				
Landi	<u> </u>	i				General 1		1			1		
	Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat			Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread			Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
da da	Inspection Strip in Tube					Drill Holes	$\vdash$	Offset		Ц.	1. 2 2333/		1 2 3 3 3

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date: 1

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

October-19-12 2:44:16 PM

Work Order ID: 92039 \*92039\* 646.9501 Parent Item: \*646 9501\* Parent Item Name: 206 Cable Cutter. High Start Date: 19/10/2012 **Required Date:** 02/11/2012 Start Qty: 1.00 Required Oty: 1.00 CCR264SS-3-06 Purchased No 110 Each 100.0000 \*\* Location Loc Oty Loc Code ST327 100 123023 123023 100 MS21059L08 Purchased No 110 Each 1,282,000 124093-20 Location Loc Oty Loc Code ST300 7 112314 7 ST314 400 123265 400 ST316 875 123100 775 123352 100 CR3213-4-05 Purchased No 110 Each 738.0000 18 13-09-03 cherry rivet Location Loc Qty Loc Code ST328 600 123301 123301 600 ST331 138 108473 38

100

108991

NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPDAT	E				
<del></del>								· · · · · ·			QA Closed:	Da	te:	
Work Ord	er: ˌ					DISPOSITION				_	PARTMENT			$\square$
Part I	•	<del></del>			<del> </del>	Rework Scrap Use-as-is Work Order Update		f Therm	Machining Sr noforming F	osstube mall Fab minishing mposite		Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Doot			1	1	Dasari	ption of work order update	 T	Initial	Action		Cian 0			
Root Cause		Date	Step	Qty		or Non-conformance Chief Eng Description				n	Sign & Date	Verificatio	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved						,								
							AUI	T CATE	GORY					45
Landi	Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend					General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/Unclea nance led I		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Forque W	raves in E	extrusion	י [	Drawing		Tout of C	Calibration					

Out of Sequence

Outside Dimensions

DQA:

Date: "

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

October-19-12 2:44:16 PM

Work Order ID: 92039

\*92039\* 646.9501

Parent Item Name: 206 Cable Cutter, High

\*646 9501\*

ST329

**Start Date:** 19/10/2012

**Required Date:** 02/11/2012

Start Qty: 1.00

Required Qty: 1.00

CR3213-4-6

CR3213-4-4

CR3213-4-2

Parent Item:

Purchased

Purchased

110

Each

400.0000 \*\*

126320 78

rivet

No

No

No

Location Loc Qty 400 123301

110

400 Each Loc Code

410.0000

Loc Code

RIVET

2W

Purchased

Location Loc Qty ST328 400 123301 400 ST331 10 104291 10 110 Each

1,019.000

\*\*

JB-83-09-03

Cherry Rivet

Location Loc Qty ST328 1000 123301 1000 ST331 19 113288 19

Loc Code

123301

											DQA:	Date:	••
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORM	MANCE / UP	PDATE			
											QA Closed:	Date:	
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Part						Rework Scrap		ſ	Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality Other
NCR	No.				<del></del>	Use-as-is Work Order Update	_	•	noforming Large Fab	Finishing Composite	Rec/Stoi	re/Packaging Supplier	Other
Root					Descri	ption of work order update		Initial	Ac	ction	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Cr	nief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data		-											
Equip/Tooling													
Operator			·										
Material													
Setup													
Other				1								,	
Process						•						# 1	
Supplier													
Training													
Unapproved													
		d:				F	AUI	LT CATE	GORY				
Land	ing (	Gear				General		_			_		
		Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre Not Concentric to O/S					BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks					Broken/Damaged		Inspecti	on Incomplete	:	Part Incorre	ct	Weld
						Burrs		Instruct	ions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		•
		Heat Trea	it			Countersink		Mislabe	led		Positioned V	Vrong	
1	Inspection Strip in Tube					Cut Too Short	Г	Misread	d		Power Loss/	Other	

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

October-19-12 2:44:16 PM

Work Order ID: 92039

Parent Item:

CR3213-4-3

646.9501

Parent Item Name: 206 Cable Cutter, High

\*92039\* \*646 9501\*

Start Date: 19/10/2012

**Required Date:** 02/11/2012

Start Qty: 1.00

1,050.000

Required Qty: 1.00

126320 JB

MS21047-3

**NUT PLATE** 

Purchased

Purchased

No

No

Location	Loc Qty
ST328	1000
123301	1000
ST331	50
116583	6
118503	4
120910	10
121243	30

110 Each

110

Loc Code

Each

125.0000

\*\*

MS21042-08

*M\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\	2=08	<b>}</b> **
USE MS21042L08		1

SHS

Purchased No Location Loc Qty ST316 125 123268 50 123301 50 123352 25

110 Each

142.0000 \*\*

Loc Code

Location		Loc Qty
ST300		42
	103668	42
ST316		100
	123352	100

Loc Code

NCR:	·															
											QA Closed:	Dat	e:			
Work Ord	ler:					DISPOSITION	7	AGAINST DEPARTMENT/PROCESS  Skid-tube Crosstube Water Jet Engineer								
Part NCR						Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite					Pro Rec/Sto	Engineering Quality Other				
*		ſ	1	, ,												
Root			6.			ption of work order update		Initial	Action		Sign &		061			
Cause	1	Date	Step	Qty		or Non-conformance	Cr	nief Eng	Description	<del></del>	Date	Verification	QC Inspector			
Doc/Data Equip/Tooling Operator																
Material	$\vdash$															
Setup																
Other	$H \mid I \mid I$								!							
Process																
Supplier																
Training	$\Box$															
Unapproved																
						F	AUI	LT CATE	GORY			\$ - 1				
Land	ing (	Gear				General		_			_	_				
		Bending				Bend		Grain			Ovalized		Pressure/Forced			
	ot Concei	ntric to C	)/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure					
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld			
Crushed/Crimped,						Burrs		Instruct	ions Incomplete/Unclear		Part Lost/M	issing	Wrong Stock Pulled			
Cuffs						Contamination		Mainte	nance		Part Moved					
		Heat Trea	at			Countersink		Mislabe	led		Positioned \	Wrong				
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	1		Power Loss/	'Surge	Other			
		Ripples ir	n Bend			Drill Holes		Offset								
		Torque V	Vaves in E	xtrusion		Drawing		Out of 0	Calibration							

Out of Sequence

Outside Dimensions

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Finish

October-19-12 2:44:16 PM

Work Order ID: 92039

646.9501

Parent Item Name: 206 Cable Cutter, High

Parent Item:

MS27039-08-13

\*92039\*

No

No

No

\*646 9501\*

**Start Date:** 19/10/2012

**Required Date:** 02/11/2012

Start Qty: 1.00

Required Qty: 1.00

\*\*

Screw

MS21059-3 Purchased

Nut Plate

AN743-13

BRACKET

Purchased

Purchased

Location Loc Qty Mezz 92 4067 92 ST307 300 123352 300

110

110

Each

Each

250.0000

392.0000

Loc Code

123350 \*\*

Location Loc Qty ST316 250 123023 50 123301 200 110 Each

20.0000

Loc Code

123301

13-08-28

Location Loc Qty Loc Code ST324 121825 ST347 10 123352 10 ST348 120242

23352

October-19-12 2:44:16 PM

										DQA:	Date:	a			
NCR: Yes	s / No				WORK ORDER NON-C	100	NFORM	MANCE / UF	PDATE	QA Closed:	Date:				
Work Order:					DISPOSITION				AGAINST DEPARTMENT/PROCESS						
Part No.  NCR No.					Rework Scrap Use-as-is Work Order Update		1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other			
Root				Descri	ption of work order update		Initial	A	ction	Sign &					
Cause	Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Des	cription	Date	Verification	QC Inspector			
Doc/Data  Equip/Tooling  Operator  Material  Setup															

#### **FAULT CATEGORY Landing Gear** General Bend Grain Ovalized Pressure/Forced Bending Centre Not Concentric to O/S BOM/Route Over/Under tolerance Temperature/Cure Hardware Broken/Damaged Cracks Inspection Incomplete Part Incorrect Weld Crushed/Crimped. Burrs Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Cuffs Contamination Maintenance Part Moved Countersink **Heat Treat** Mislabeled Positioned Wrong Inspection Strip in Tube Power Loss/Surge Other **Cut Too Short** Misread Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence

Outside Dimensions

Wave/Twist in Tube

Folio

Other Process Supplier Training Unapproved

October-19-12 2:44:16 PM

Work Order ID: 92039

Parent Item:

646.9501

Parent Item Name: 206 Cable Cutter, High

\*92039\*

\*646 9501\*

Start Date: 19/10/2012

125709 23

**Required Date:** 02/11/2012

Start Qty: 1.00

Required Qty: 1.00

AN3-3A

CCR264SS3-04

CR3212-5-4

Purchased

Purchased

No

No

Location Loc Qty ST350 355 122416 55 122800 200 123352 100

110

110 Each 646.0000

Each

12

\*\*

Purchased

No

Location Loc Qty ST327 200 123352 200 ST331 446 17997 446 110 Each

368.0000

Loc Code

Loc Code

355.0000

Loc Code

\*\*

SP 13-08-28

Cherry Rivet

Location Loc Qty ST328 200 123301 200 ST330 168 120308 68 120410 100

120308

NCR:	Yes / No	)			WORK ORDER NON-C	CONF	ORN	MANCE / UPI	DATE						
		QA Closed: Date:													
Work Ord	er:				DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Part f	No				Rework Scrap Use-as-is Work Order Update	Machining Small Fab Thermoforming Finishing			Î	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other				
		1	1								· · · · · · · · · · · · · · · · · · ·				
Root					ption of work order update	Init			tion	Sign &		001			
Cause	Date	Step	Qty		or Non-conformance	Chie	t Eng	Descr	ription	Date	Verification	n QC Inspector			
Doc/Data															
Equip/Tooling	$\vdash$			:											
Operator	$\vdash$			,											
Material	$\square$											· · · · · · · · · · · · · · · · · · ·			
Setup	$\dashv$														
Other															
Process	$\vdash$														
Supplier Training	$\vdash$														
Unapproved	$\vdash$											<i>.</i> ·			
опаррточец	L	-			F	AULT (	CATE	GORY		L		<u> </u>			
Landi	ng Gear				General					• •	,				
	Bendin	 g.~			Bend	∏ <sub>G</sub>	rain			Ovalized		Pressure/Forced			
		Not Conce	ntric to	o/s	BOM/Route	Н	ardwa	re	<u></u>	Over/Under	tolerance	Temperature/Cure			
	Cracks				Broken/Damaged	In	specti	on Incomplete		Part Incorre	ct	Weld			
'	<del></del>				Burrs	$\boldsymbol{\vdash}$		ions Incomplete/l	Jnclear	Part Lost/Mi	issing	Wrong Stock Pulled			
	Cuffs				Contamination	М	lainte	nance		Part Moved	•				
	Heat Treat Countersink						lislabe	led		Positioned V	Vrong				
	Inspection Strip in Tube Cut Too Short						lisread	ł		Power Loss/	Surge	Other			
	Ripples in Bend Drill Holes						ffset		<b></b>	•	•				
	Torque Waves in Extrusion Drawing						ut of C	Calibration							
	Turning	Sequence	i		Finish	По	ut of S	Sequence		·					

Outside Dimensions

DQA:

Date: "

Wave/Twist in Tube

October-19-12 2:44:16 PM

Work Order ID: 92039

646.9501

Parent Item Name: 206 Cable Cutter, High

\*92039\*

\*646 9501\*

Location

106578

108738

112314

ST331

Start Date: 19/10/2012

**Required Date:** 02/11/2012

Start Qty: 1.00

Required Oty: 1.00

CCR264SS3-2

Parent Item:

Purchased

No

110

Each 154.0000

124876 78

NAS1835-08

Purchased

No

154 104 2 48 110 Each

Loc Qty

50.0000

Loc Code

Loc Code

\*\*

Insert

No Purchased

Location Loc Qty ST298 50 123055 40 123078 10 110 Each

123055 400.0000

Location ST328

123301

Loc Oty 400 400 Loc Code

123301

NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPI	DATE			
											QA Closed:	Date:	
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
	Part No.					Rework Scrap	ſ	Skid-tube Machining Moforming	Crosstube Small Fab	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other	
NCR I	NCR No.					Use-as-is Work Order Update	_		Large Fab	Composite	, Rec/Stor	Supplier	Other
Root			Ĩ		Descri	ption of work order update		Initial	Act	ion	Sign &		
Cause		Date	Step	Qty	. (	or Non-conformance	Ch	nief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator					*		1						
Material													
Setup							l						· ·
Other													
Process													
Supplier			1										
Training													
Unapproved					*								
						F	AUL	T CATE	GORY				
Landi	ng (	Gear				General		_			_		_
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
						Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crushed/Crimped Burrs							Instruct	ions Incomplete/l	Jnclear	Part Lost/M	issing.	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		_
		Heat Trea	it			Countersink		Mislabe	led		Positioned \	Wrong	
		Inspection	n Strip in	Tube		Cut Too Short		Misread	I		Power Loss/	'Surge	Other
	Ripples in Bend Drill Holes Offset												

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date: \*

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

October-19-12 2:44:16 PM

Work Order ID: 92039

646.9501

Parent Item Name: 206 Cable Cutter, High

\*92039\*

\*646 9501\*

**Start Date:** 19/10/2012

**Required Date:** 02/11/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Parent Item:

Purchased

No

110

Each

1,196.000

<u>Locatio</u>	<u>n</u>	Loc Qty	Loc Code
308		168	
	122452	168	
ST291		672	
	117423	71	
	119075	1	
	120308	44	
	121011	43	
	121243	500	
	121708	13	
ST305		356	•
	123265	356	
		110 Each	18.0000

\*\*

MS35842-11

647.1210

Purchased

Manufactured

No

No

Location	Loc C	<u>)ty</u>	Loc Code		
ST438		18			
91438		18			
	110	Each	8.0000		

Location Loc Qty Loc Code ST290A

123023

123023

												DQA:	Date:	4:		
NCR:	Yes	/ No					WORK ORDER NON-O	100	NFORM	AANCE / UP	DATE	QA Closed:	Date:			
	DISPOSITION AGAINST DEPARTMENT/PROCESS															
Work Ord	er:											٦		, <u>-</u>		
Part NCR		<u>.</u>					Rework Skid-tube Crosstu  Scrap Machining Small F  Use-as-is Thermoforming Finishi  Work Order Update Large Fab Compos					Prod. Eng. Coor. Quality Rec/Store/Packaging Other				
-													-			
Root Cause		Date	Sten	Otv	Des		otion of work order update	1	Initial lief Eng		tion ription	Sign & Date	Verification	QC Inspector		
oc/Data quip/Tooling perator faterial etup other rocess upplier raining		,	Date Step Qty or Non-conformance					, L. 1. 16		·						
		-					F.	AUL	T CATE	ORY				- 1		
Land	ng (	Gear					General		_			_		_		
		Bending Centre Not Concentric to O/S Cracks Crushed/Çrimped. Cuffs Heat Treat Inspection Strip in Tube					Bend BOM/Route Broken/Damaged Burrs Contamination Countersink		Instructi Mainte Mislabe	on Incomplete ons Incomplete/ nance Ied	/Unclear	Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong				
	<u> </u>	i		Tube			Cut Too Short		Misread			Power Loss,	'Surge	Óther		
		Ripples in					Drill Holes	_	Offset			***	/	/		
		Torque W			ו		Drawing		1	alibration				100 T		
	1	Turning Sa	equence				Finish	1	IOut of S	equence			1			

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

October-19-12 2:44:16 PM

Work Order ID: 92039

\*92039\*

Parent Item:

646,9501

\*646 9501\*

Parent Item Name: 206 Cable Cutter, High

**Start Date: 19/10/2012** 

**Required Date:** 02/11/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-08-11

Purchased

No

110

Each 646.0000

Loc Code

25654 18

Location Loc Oty 309 100 122441 100 ST292 46 120833 46 ST307 500 123352 500 110 Each

MS27039-08-06

Rurchased

No

No

No

ShB

Purchased

Location Loc Qty ST293 100 117065 100 110 Each Loc Code

100.0000

51.0000

MS27039-08-09

MS27039-08-12

Purchased

Location Loc Qty Mezz 51 11187 51 110 Each Loc Code

131.0000

8813-08-28

Screw

Location Loc Qty Mezz 31 1850 31 ST307 100 123352 100

Loc Code

											DQA	: Da	te:	•	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFOR	MANCE / UPE	DATE					
										***	QA Closed	: Da	te:		
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMEN	T/PROCESS			
Work Ord	er.				<del></del>	Rework	7		Skid-tube	Crosstube	pe Water Jet Engineerin				
Part I	VΩ										l Pr	od. Eng. Coor.	-	Quality	
						Use-as-is	1	3	noforming	Small Fab Finishing	-	ore/Packaging	-	Other	
NCR I	۷o.				i	Work Order Update	1		Large Fab	Composite	1	Supplier			
,															
Root					Descri	ption of work order update		Initial	Act	ion	Sign &				
Cause		Date	Step	Qty	(	or Non-conformance	Cr	nief Eng	Descr	iption	Date	Verificatio	n	QC Inspector	
Doc/Data															
Equip/Tooling															
Operator															
Material															
Setup												, .			
Other															
Process															
Supplier															
Training															
Unapproved											<u> </u>	1			
						F	AUI	T CATE	GORY			7,5 7 4 4 4 4	• •	V Pro V	
Landi	ng (	Gear				General		,		<b></b>	٦			1	
Bending						Bend		Grain			Ovalized			Pressure/Forced	
	L	Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	ire		Over/Under tolerance			Temperature/Cure	
		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorrect		Weld		
Crushed/Crimped. Burrs							Instruct	ions Incomplete/L	Inclear	Part Lost/Missing			Wrong Stock Pulled		

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Lost/Missing Part Moved

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

October-19-12 2:44:16 PM

Work Order ID: 92039 \*92039\* Parent Item: 646.9501 \*646 9501\* Parent Item Name: 206 Cable Cutter, High **Start Date:** 19/10/2012 **Required Date:** 02/11/2012 Start Oty: 1.00 Required Qty: 1.00 MS27039-1-11 Purchased No 110 Each Location Loc Qty Loc Code Mezz 37 9662 37 ST305 100 123352 100 CR3212-4-4 Purchased No 110 Each Location Loc Qty Loc Code ST328 200 123346 200 MS24694-S8 Purchased No 110 Each Screw Location Loc Qty Loc Code ST302 200 123348 123348 100 123352 100 AN3-10A Purchased No 110 Each 251.0000 125709 yB Location Loc Qty Loc Code ST351 251 120873 17 122800 234 √ Manufactured 110 Each 0.0000 13-08-28

October-19-12 2:44:16 PM

**Shop Packet Print** 

Page 12

											DQA:	Date	): <u>*</u>			
NCR:	Yes	/ No				WORK ORDER NON-	100	VFOR	MANCE / UPDAT							
										I	QA Closed:	Date	<u>::</u>			
Work Order:						DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Work Ord	CI.					Rework	1		Skid-tube Cr	rosstube		Water Jet	٦	Engineering		
Part I	Vo.					1			Machining Small Fab Prod. Eng. Coor.					Quality		
						Use-as-is				Finishing	Rec/Store/Packaging Other			Other		
NÇR No.						Work Order Update				mposite		Supplier				
					,					· · · · · · · · · · · · · · · · · · ·						
Root					L	ption of work order update	1	Initial	Action		Sign &					
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Descriptio	n	Date	Verification	$\bot$	QC Inspector		
Doc/Data																
Equip/Tooling																
Operator														•		
Material																
Setup		]												•		
Other																
Process																
Supplier		]		l												
Training		· .														
Unapproved														-		
						F	ΑUL	T CATE	GORY							
Landi	ng (	Gear				General		_	•			_				
	Bending					Bend	Grain			Ovalized		P	ressure/Forced			
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under tolerance			emperature/Cure		
	Cracks					Broken/Damaged		Inspecti	ion Incomplete		Part Incorrect		]v	Veld		
		Crushed/	Crimped.			Burrs	$\prod$	Instruct	ions Incomplete/Uncle	Part Lost/Mi	ssing	$\neg$ v	Vrong Stock Pulled			

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

October-19-12 2:44:16 PM

Work Order ID: 92039	*92039*	,			
Parent Item: 646.9501	*646 9501*				
Parent Item Name: 206 Cable Cutter, High	(7(7.7.7.7)			Start Date: 19/10/2012         Required Date: 02/11/2012           Start Qty: 1.00         Required Qty: 1.00	12
*600.0990 Purchased	No	110	Each	126215	
Magnabond 6398 Part A (One 4 oz can) 600.0991  *600 0991  Magnabond 6398 Part B (One 4 oz can)  Purchased	No	110	Each	0.0000 ** 1 26 215 ps	
*600.1012 * Sealant (One 6 oz Semkit) Purchased	No	110	Each	0.0000 ** 126248 g 8 13-08-2	: <b>8</b> >

										DQA:	Date:	•
NCR:	Yes / No	•			WORK ORDER NON-CONFORMANCE / UPDATE						······	
										QA Closed:	Date:	
Work Ord	er:				DISPOSITION	AGAINST DEPARTMENT/PROCESS						
Part I					Rework Scrap	Skid-tube Crosstube Machining Small Fab			Water Jet Prod. Eng. Coor.		Engineering Quality	
NCR I	No			۶				Finishing Composite	Rec/Sto	re/Packaging Supplier	Other	
Root				Descri	ption of work order update		Initial	Act	ion	Sign &		
Cause	Date	Step	Qty	C	or Non-conformance	Cr	nief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling								İ				
Operator		1						į				· .
Material		İ						Í				
Setup												
Other		ļ										
Process						1		ł				
Supplier		1			,							
Training												
Unapproved							٠					
					F	AUI	T CATE	GORY				
Landi	ng Gear				General		_			<b>-</b>	<b>.</b>	
	Bending				Bend	Grain			Ovalized		Pressure/Forced	
	Centre N	ot Concer	ntric to (	o/s	BOM/Route		Hardwa	Hardware			tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspection Incomplete			Part Incorre	ct	Weld
İ	Crushed/	Crimped.			Burrs		Instructions Incomplete/Unclear			Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination		Maintenance			Part Moved		
	Heat Trea	at			Countersink		Mislabe	led		Positioned \	Vrong	
	Inspectio	n Strip in	Tube		Cut Too Short		Misread	1		Power Loss,	'Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

# Work Order ID 92039

\*92039\*

October-19-12 2:44:12 PM .

**Required Date:** 02/11/2012

Item ID:

646.9501

Accept

\*N900040100\*

Setup Start

**Revision ID:** 

Item Name:

206 Cable Cutter, High

**Start Date:** 19/10/2012 Start Qty: 1.00 Reg'd Qty: 1.00 \*1\* \*1\*

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan: MLゴ

Date: 12-10-19 Tooling:

Date:

Start Run

QC:

Date:

SPC (Y/N):

**Run Hours** 

Date:

Stop

Sequence ID/ **Work Center ID** 

Operation Description Set Up/

Tool ID

Tool# Plan

Code

Accept

Qty

Reject Reject Number Qty

Insp. Stamp

**Draw Nbr** 646,9500

**Revision Nbr** 

100

N/C

0.00

NLJ 13-08-28

\*100\*

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP 646.9501

110

Pick Kit

0.00

\*110\*

Packaging

Memo

0.00

Packaging

120

QC4-100% Inspect kits for completeness

0.00

\*120\*

QC

Memo

0.00

Quality Control